

Standard Cleaning and Packaging(FC-01)

Revision A

Scope

FITOK Specification FC-01 defines the cleaning, lubrication, assembly, and packaging requirements for standard FITOK products and describes the practices used to meet these requirements.

FC-01 covers basic industrial procedures. The system designer and user should review this specification to determine whether it meets the user's cleaning needs.

Specification Requirements

- ⦿ Products are cleaned by ultrasonic agitation equipment and pure water.
- ⦿ Products shall be cleaned to remove loose particles and cutting oils that typically remain on products and components following industrial manufacturing processes.
- ⦿ Products shall be assembled in a clean and well-lighted area to avoid the contamination.
- ⦿ Assembled products shall be lubricated as required by product specifications.
- ⦿ Finished products shall be packaged and boxed for protection during shipment and storage. Packages shall be marked for identification.

Cleaning Practice

- ⦿ Components are cleaned to remove oil, grease, and loose particles. Carbon steel components are protected from atmospheric corrosion by plating, a conversion coating, or a light oil film. Brass components may be bright dipped to inhibit tarnish of exterior surfaces.
- ⦿ Cleaned components are packaged to protect them from damage during storage.

Lubrication, Assembly, and Testing Practice

- ⦿ Lubricants and coatings are applied to threads, mating surfaces, O-rings, and seals, in accordance with individual product specifications, to prevent galling, reduce friction, and ensure proper sealing. Lubricants and coatings are hydrocarbon or halocarbon-based compounds or silicones and may contain inorganic additives or leachable halogens.
- ⦿ Products are assembled from cleaned components in a clean, well-lighted area.
- ⦿ Unless otherwise required, production tests are performed by internally pressurizing with clean, dry air, nitrogen, or helium as required by product specifications.
- ⦿ The water used in leak-test are based on multistep filtering.

Packaging Practice

- ⦿ Finished products are packaged to protect them from contamination and damage during shipping and storage.
- ⦿ Exposed male threads are capped when necessary for protection. Standard quantities of products are packed in cardboard boxes with suitable protective material.
- ⦿ Boxes are identified with the part number, quantity, and packaging date code.